

SPLIT

Work Order ID 54335-1

January 13, 2010 11:27:13 AM



Page 1

Item ID: D3762-041

Accept



Setup Start



Revision ID:

Item Name: Front Leg Fitting Assembly

10



Stop



Start Date: 12/08/09 Start Qty: 40.00



Cust Item ID:

Required Date: 12/16/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

u

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3762	Rev A
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100	Pick Kit	0.00
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Packaging	Memo	0.00
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Packaging		
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110	Large Fab	0.00
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Large Fab	Memo	0.00
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Large Fab		
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1- assemble as per dwg D3762 using locating pins DT9014 and tack weld parts
in place 2- take pins out before welding 3-weld as per dwg D3762 per
QSI004 Alum. rod Batch: m111311

10.01.14

12 2

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC	Memo	0.00
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Quality Control		
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PD 10.01.14

P10 →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3762-041 PAR #: N/A Fault Category: Large Fab NCR: Yes No DQA: A Date: 10-01-19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: S Date: 10/01/26

NCR: 54335		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/14	# 110	one welded assembly scrap due to welder welding no close + melting inside the hole on D3762-3	RB 09/14/12	-Scrap + Destroy no replace Qly x1	PL 10-01-14	S 10/01/14	R 09/14/12	S 10/01/14
		R.C. First time welding these parts + process	X	X	X	X	X	
10/1/14	# 110	Qly x1 D3762-3 scrap. welder touch part with torch and left tungsten in part. R.C. Human error	RB 09/14/12	SCRAP + DESTROY QLY X1 D3762-3 + Replace QLY X1 B# 54370	PL 10-01-14	S 10/01/14	R 09/14/12	C 10/01/14

NOTE: Date & initial all entries

LQA

Work Order ID 54335

January 13, 2010 11:27:13 AM



Page 2

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Required Date: 12/16/09 Req'd Qty: 40.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan

Code

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

⇒ Start 10/01/14

(YR)

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

SAD 10-01-14

12

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

M 10/01/14

(X12) ✓

Work Order ID 54335

January 13, 2010 11:27:14 AM



Page 3

Item ID: D3762-041

Accept



Setup Start



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Stop



Start Date: 12/08/09 Start Qty: 40.00



Cust Item ID:

Required Date: 12/16/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: G ASet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

80 10101 | 14

12

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/01/15 JF

Memo

0.00

MF 10-1-14

Picklist Print

Page 1

January 13, 2010 11:27:12 AM

Work Order ID: 54335



Parent Item: D3762-041



Parent Item Name: Front Leg Fitting Assembly

Start Date: 12/08/09

Required Date: 12/16/09

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified:EC

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3762-1		Manufactured	No			110	Each	26.0000	12.0000		<i>PL 10-01-14</i>	

Fitting

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

26

54366

D3762-3

Manufactured No

100 Each 16.0000 6.0000

26

Tube



Warehouse

Location

Main Warehouse

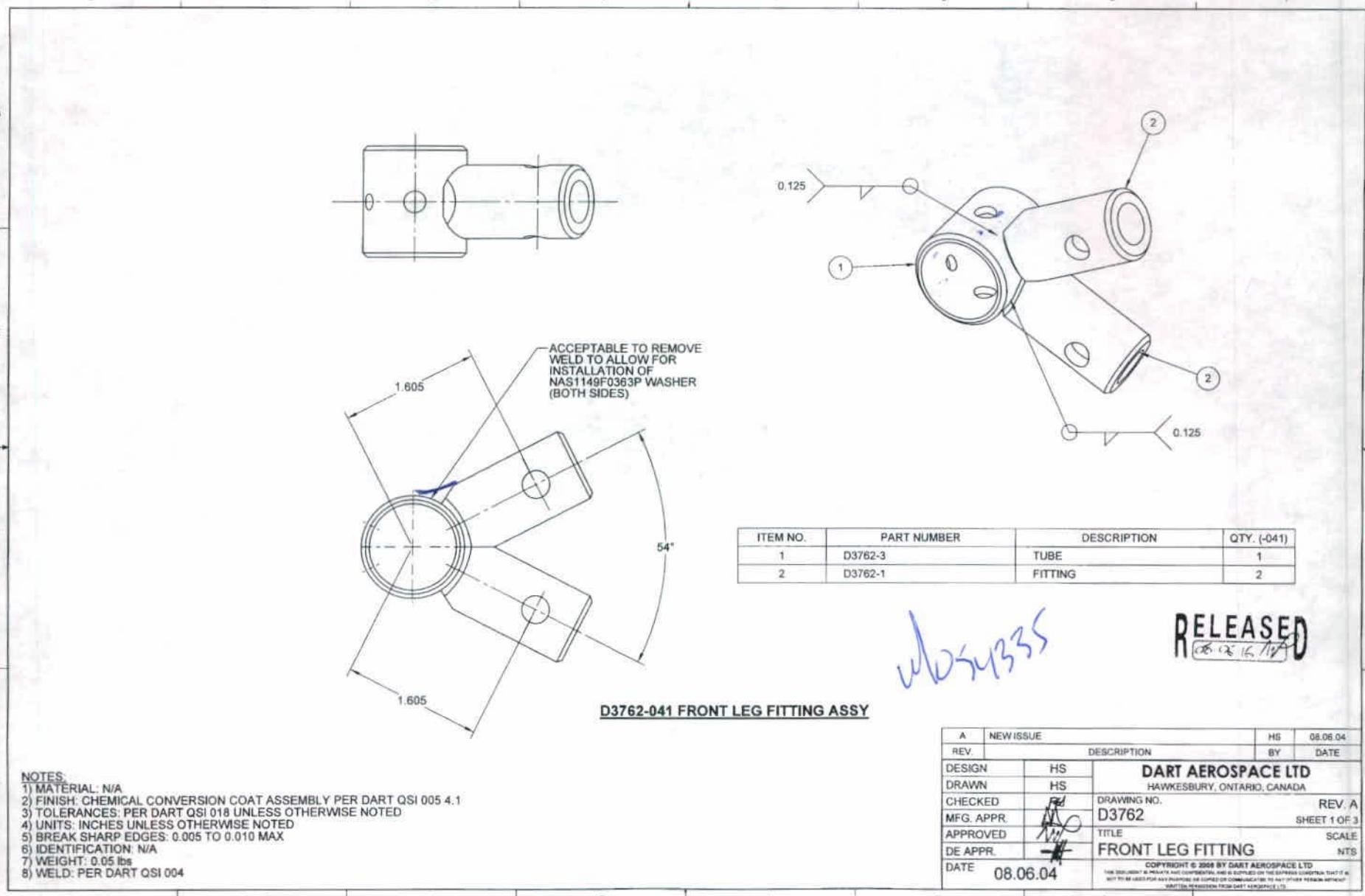
ST

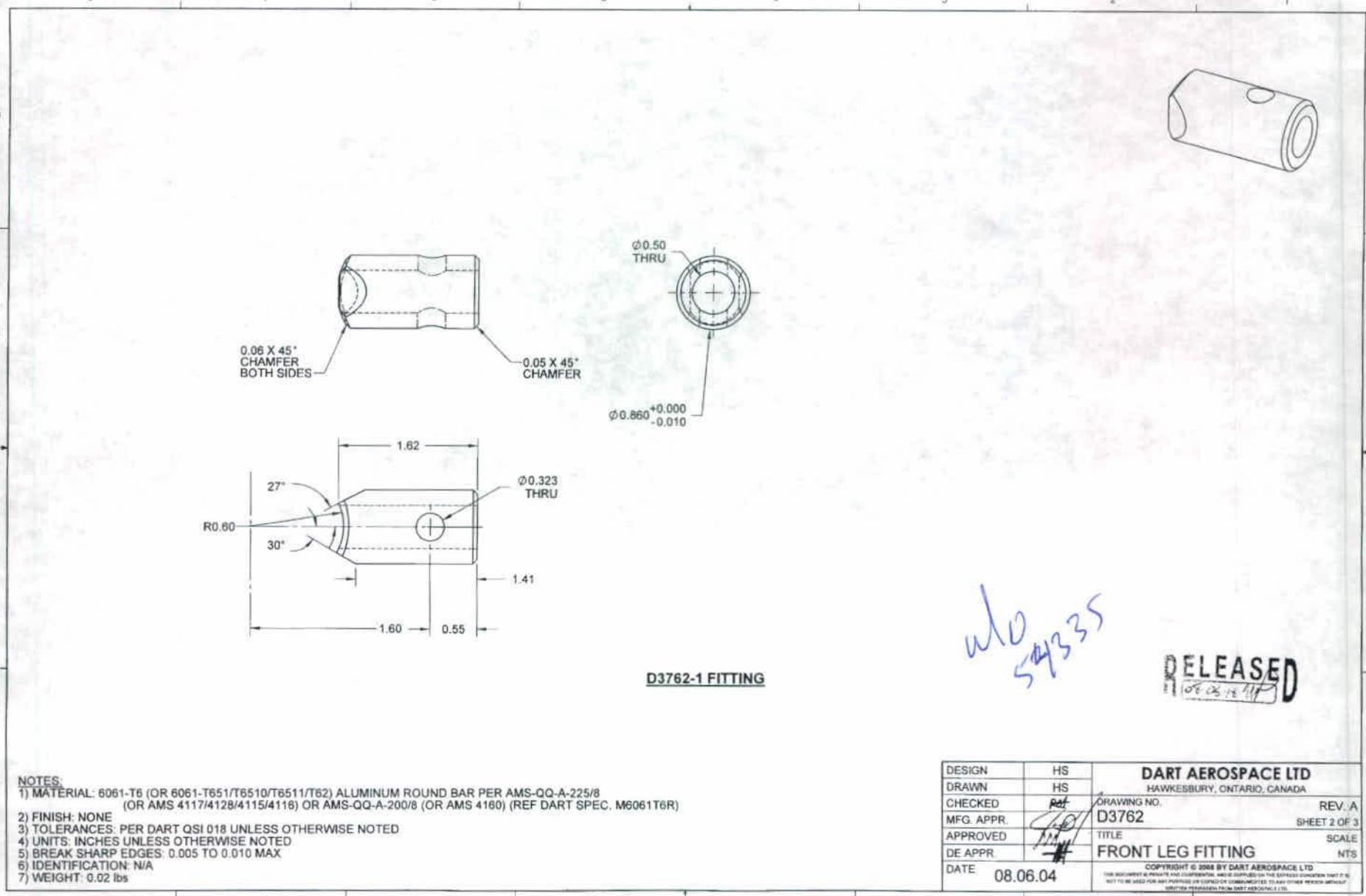
Loc Qty

Loc Code

16

5437014*T*





DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3762	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FRONT LEG FITTING	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

